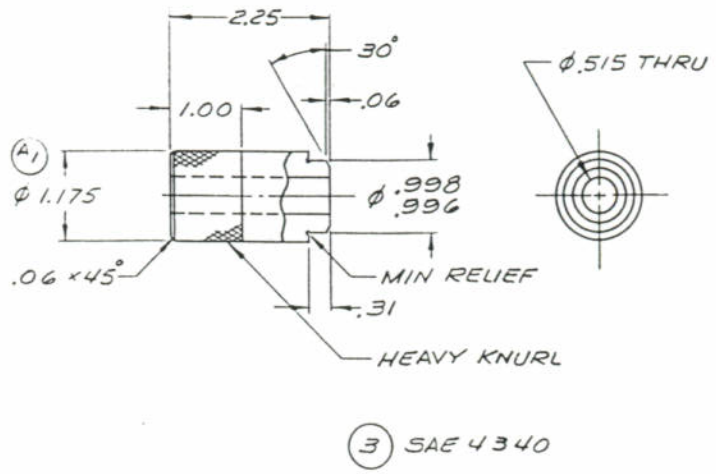
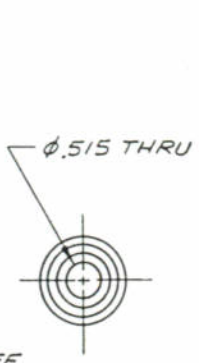
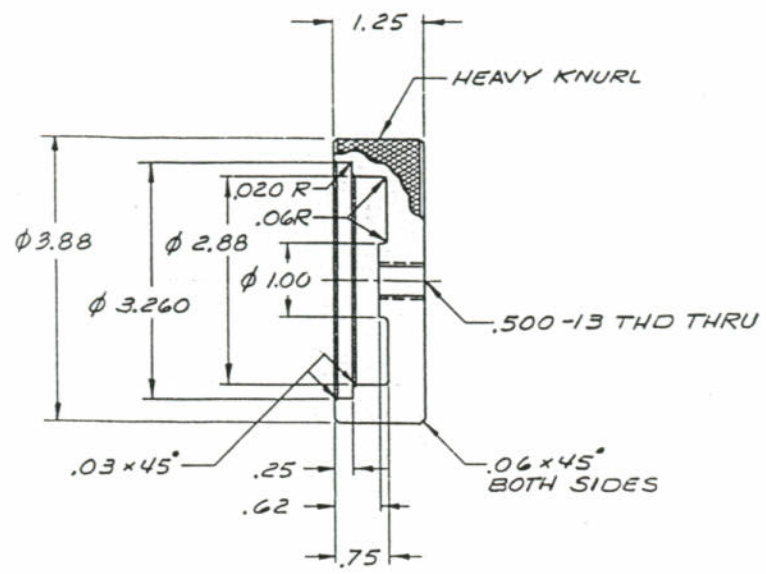


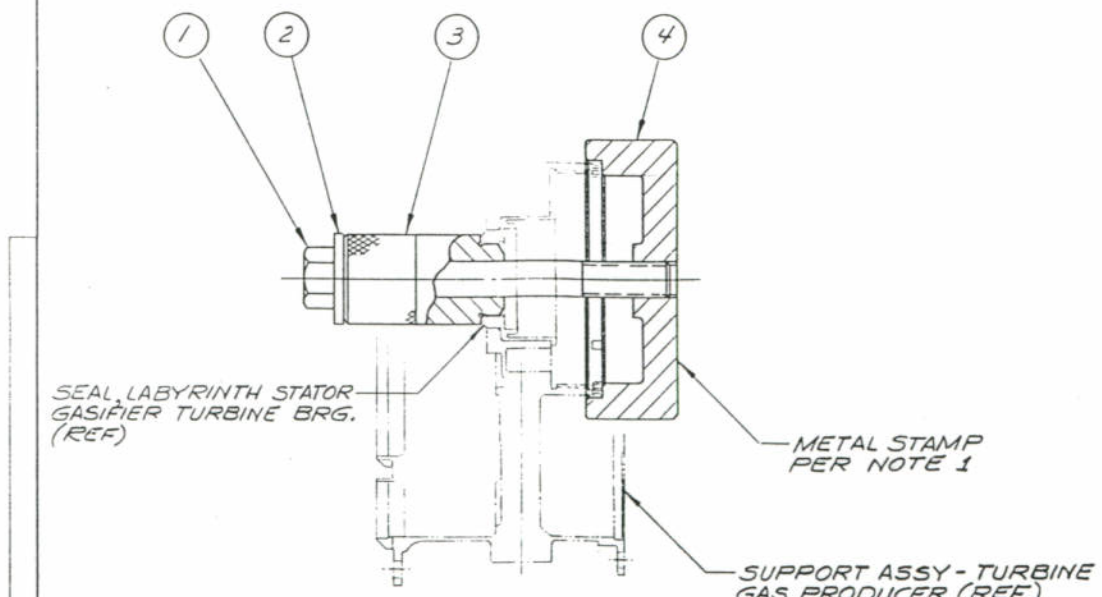
(3) SAE 4340





(4) SAE 1010-1020

REVISIONS					
MICRO-FILMED	ZONE	LTR	DESCRIPTION	DATE	APPROVED
X		A	(1) HAS #1.250 GB	9-2-2	[illegible]



REF—

FORM 8520 (REV. 3-76)

4	1	NUT			STL
3	1	SLEEVE			STL
2	1	PLAIN WASHER		FOR .500 DIA SCR	STL
1	1	HEX HD CAP SCR		.500-13 x 4.75 LG	STL
ITEM NO.	NO. REQD	NOMENCLATURE OR DESCRIPTION	CODE IDENT	PART OR IDENTIFYING NO.	MATERIAL OR NOTES

FOR PART IDENTIFICATION ITEM NUMBERS ARE EXPRESSED AS DASH NUMBERS IN THIS BASIC DRAWING, EXCEPT WHERE A NUMBER APPEARS IN THE PART OR IDENTIFYING NUMBER COLUMN

REDUCED PRINT

These tool drawings are furnished in accord with the terms of the Allison Tools Release Agreement. The aperture cards or drawings are to be maintained in the custody of the recipient and shall not be disclosed to any third party without specific written consent of Allison Gas Turbine Division, G.M.C.

NOTES:

1. MARK AS SPECIFIED IN LOCATION SHOWN WITH 1/8-3/16 HIGH FIGURES THE FOLLOWING:
   a) THE NAME "ALLISON" FOLLOWED BY THE TOOL NUMBER AND LAST CHANGE LETTER.
   b) VENDOR NAME OR TRADEMARK.
2. BLACK OXIDE PER AMS 2485 ITEMS 1, 2, 3 & 4
3. BREAK SHARP EDGES .020 MAX

EACH ITEM PURCHASED SEPARATELY MUST BE STAMPED OR ETCHED WITH TOOL NUMBER AND DETAIL NUMBER IF SUITABLE OR SUFFICIENT AREA NOT AVAILABLE, ATTACH TAG.

GEOMETRIC CHARACTERISTIC SYMBOLS

FLATNESS	PERPENDICULARITY	Ⓜ OR MMC (MAX MATL CONDITION)	
STRAIGHTNESS	// PARALLELISM		
ROUNDNESS	∠ ANGULARITY	Ⓛ OR LMC (REGARDLESS OF FEATURE SIZE)	
CYLINDRICITY	↗ RUNOUT		
PROFILE OF A LINE	⊕ TRUE POSITION	.XXXX BASIC DIM	
PROFILE OF A SURFACE	○ CONCENTRICITY	⌀ DIAMETER	
	⌯ SYMMETRY	-A- DATUM IDENT	

UNLESS OTHERWISE SPECIFIED:
ALL TRUE POSITION TOLERANCES AND RELATED DATUMS MMC.
ALL OTHER FORM AND POSITIONAL TOLERANCES AND RELATED DATUMS RFS.
SEPARATE TRUE POSITION CALLOUTS MAY BE GAGED SEPARATELY REGARDLESS OF DATUM REFERENCE.
RUNOUTS ARE CIRCULAR.

UNLESS OTHERWISE SPECIFIED	APPROVALS	DATE
TOL. ON ANGLES ± 1°	DRAWN Summerfield	77-10-14
TOL. ON 3 PLACE DECIMALS ±.010	CHECKED [illegible]	78-2-16
TOL. ON 2 PLACE DECIMALS ±.02	CHF. DR. [illegible]	78-2-16
MATL. SEE NOTE	MET.	
HEAT TREAT AND HARDNESS	ENGR. 1 GR SHOLD	77-10-13
	ENGR. 2	
	ENGR. 3	
	FINAL E. Reed and [illegible]	7-10-24
SURFACE TREAT. NOTED	INSPECTION	REVIEW APPROVAL

6897513

SAE 4340
SAE 1010-1020
AMS 2485
LOCAL SPECS. (REF)

DRAWING PRACTICE
SURFACE TEXTURE
SCREW THREADS
GENERAL SPECIFICATIONS — SPEC. SUMMARY

Allison GAS TURBINE OPERATIONS General Motors Corporation Indianapolis, Indiana

TITLE
PULLER-GAS PRODUCER LABYRINTH SEAL

MODEL (FIRST USAGE) 250 SERIES | APPLICATION: SEE SEPARATE PARTS LIST

SIZE	CODE IDENT.	DWG. No.
D	63005	6897513

SCALE 1/1 | SHEET

SHOP COPY